

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011093**Date Inspected:** 08-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Ye yong jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

**Milling area**

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040491 perform FCAW welding on, 109 mtr. Skin C stiffener plate, weld joint identified as NSD1-FESA3-3 C/C- 11. ZPMC CWI Identified as Mr. Liu zhong an. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2314-TC-P4.

2.This QA inspector, Baskar Govindarajan, observed Transverse indication of 2 mm while performing 10% Magnetic particle testing (MT) in North tower, Lift 3, 99 mtr. Skin D fit lug no. NSTL3- 3 G/K-155.Incident reported.

**Heavy dock –Jetty**

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053486 perform FCAW Tack welding on, outside bearing plate stiffener in Skin B, of East tower, lift 1, weld joint identified as ESD1-SA 296 B/E-30, 34. ZPMC CWI Identified as Mr.Ye yong jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2333-TC-P4-F.

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## WELDING INSPECTION REPORT

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 062126 perform FCAW repair welding on, inside stiffener, in west tower, lift 1, weld joint identified as WSD1-A 423 B/H-72, 73. ZPMC CWI Identified as Mr. Ye yong jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P5-F.

### Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as North tower, Lift 3, 99 mtr. Diaphragm and fit lugs on Skin C & D. The weld designations reviewed are as follows:

NSTL3- 3 G /K – Jt. nos -72,78,109,157,168,173,174 – diaphragm to Skin

NSTL3- 3 G /K – Jt. nos – 14,15,16,80,81,99,100,171,172 – Fit lugs

NSTL3- 3 G /K – Jt. no – 155 – Fit lugs

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar,Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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